

Asst by Sept. 8th / 2011

Work Order ID 73206



Friday, August 26, 2011 7:11:59 AM

Item ID: D412-785-002-203

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Assembly

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/08/12 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D412-785-002-101 B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

11/09/13

2

110

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

11/09/14

2

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/09/14

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73206

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Page 2

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 11/09/14		2	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

2x 0 m-11/09/14

counted
2 0 M 11/09/14

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73206

Friday, August 26, 2011 7:11:59 AM



Page 4

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Accept



Setup Start



Revision ID:

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

~~M2024 T3 1.25 X-063 2118881 1.25 11/09/14~~MF
11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:11:56 AM

Page 1

Work Order ID: 73206

Parent Item: D412-785-002-203

Parent Item Name: Angle Assembly

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-08-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6A1.00X.500W .063		Purchased	No				f	0.0000		0.526316			
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angle 1.00 x .500 x .063w

MS20426AD3-43	MS1042	Purchased	No				Each	5,040.000		8			
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RIVET

47119099 (84)

Location

Loc Qty

Loc Code

ST316

5040

104374

1122

110398

3918

MS21075L08

		Purchased	No				Each	86.0000		4			
--	--	-----------	----	--	--	--	------	---------	--	---	--	--	--



ANCHOR NUT

Location

Loc Qty

Loc Code

ST303

86

111578

86

M2024T3 1.25 x .063

M118881

1.25 11/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

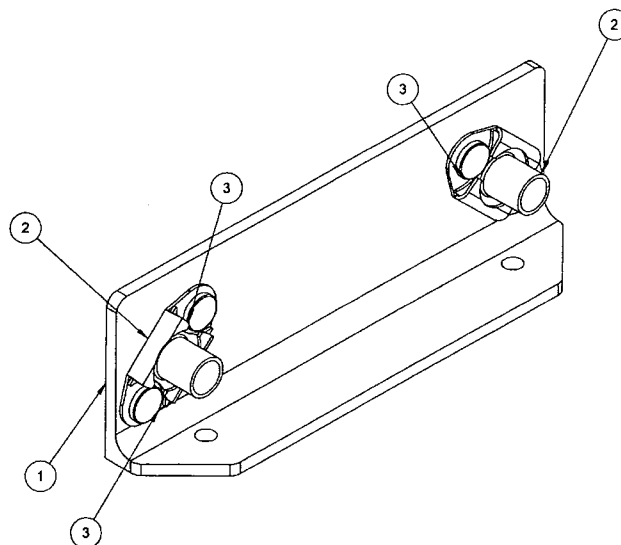
DART AEROSPACE LTD		Work Order: 73206
Description: Angle		Part Number: 412 785 002 203
Inspection Dwg:	Rev: B	Page 1 of 1

412 785 002 101

X	First Article	X	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.63	$\pm .030$	2.625	—		RA26	Very
1.875	$\pm .010$	1.882	—		"	
.375	$\pm .010$.370	—		"	
.125	$\pm .030$.1253	—		"	
.188	$\pm .030$.1882	—		"	
.150	$\pm .030$.1495	—		"	
.127	$\pm .030$.1272	—		"	
.115	$\pm .030$.1146	—		"	
.469	$\pm .010$.479	—		"	
.235	$\pm .010$.240	—		"	
$\phi .189$	$\pm .005$	$\phi .189$	—		"	
$\phi .098$	$\pm .001$	$\phi .099$	—		"	
$\phi .079 \times 100^\circ$	$\pm .010 \quad 16^\circ$.180 $\times 100$	—		"	

ITEM NO.	QTY. -203	PART NUMBER	DESCRIPTION
1	1	D412-785-002-403	ANGLE
2	2	MS21075L08	NUTPLATE
3	4	MS20426AD3-4	RIVET





D412-785-002-203 ANGLE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73206
C211108124

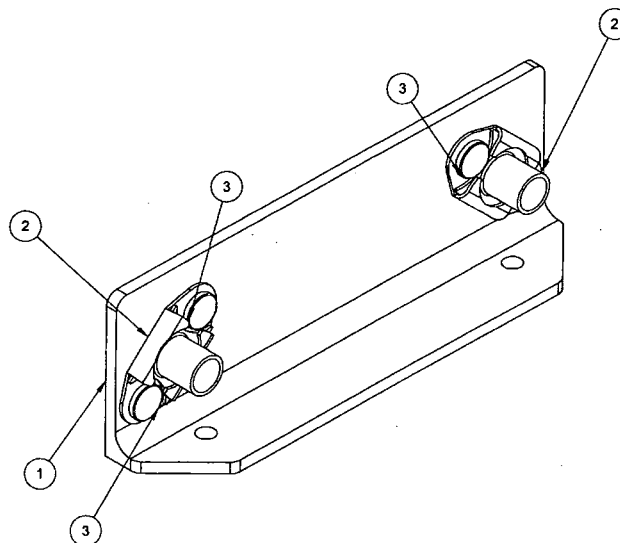
RELEASED
10/6/25 NP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-002-101	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.	N/A	GPS PANEL INSTALLATION	NTS
DATE	09.10.09	COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE	
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ITEM NO.	QTY. -203	PART NUMBER	DESCRIPTION
1	1	D412-785-002-403	ANGLE
2	2	MS21075L08	NUTPLATE
3	4	MS20426AD3-4	RIVET



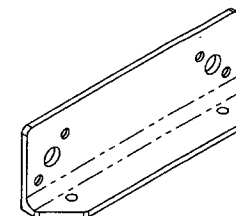
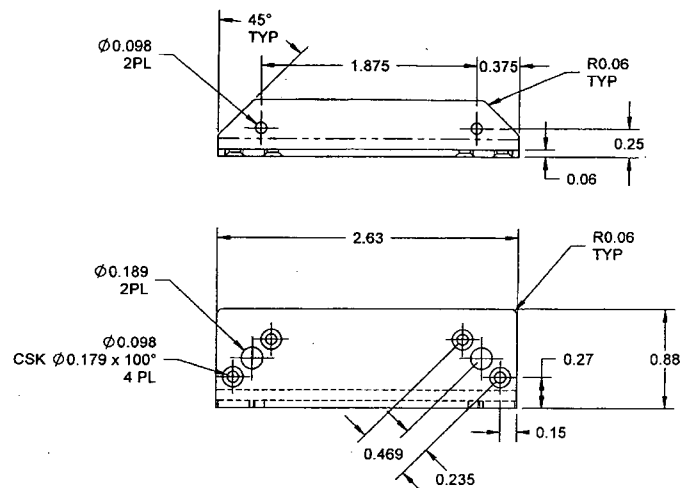
D412-785-002-203 ANGLE ASSEMBLY

RELEASED
10/8/25 M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D412-785-002-403 ANGLE

RELEASED
6/6/25 1/10

- See Attached E-mail*
- NOTES:**
- 1) MATERIAL: 6061-T6/7050-T6 ALUMINUM ANGLE PER AMS-QQ-A-200/8
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QQ-C-008 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-002-101	SHEET 7 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	GPS PANEL INSTALLATION	NTS
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From: Harvey Siemens <hsiemens@dartaero.com>
Sent: September 12, 2011 5:26 PM
To: L Lacelle; Jean-Luc Menard
Subject: Angle

Linda/JL

There are 2' of 2024, 1.25 x 1.25 (sorry the size changed when they actually measured it) angle headed your way for the production of D412-785-002-403/-405.

It is acceptable to substitute the 2024 material for the 6061 material called out in the drawing.

You should see them tomorrow. They are coming to your attention JL.

Let me know if there's anything else that you need.

Regards,

Harvey Siemens
Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
F: 403-717-1288
E: hsiemens@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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